

# Work Order ID 82133

\*82133\*

March-23-12 10:47:00 AM

Page:1

Item ID: D2938-1

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Saddle LH Out, 206

Start Date: 23/03/2012 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 06/04/2012 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/03/23

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2938

Rev C

100

0.00

\*100\*

HAAS I

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number.1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

6 RT 12-05-27

110

0.00

\*110\*

Mill Conv

CONVENTIONAL MILLING MACHINE

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

6 RT 12-05-28

120

QC1- Inspect dimensions to dimension sheet

0.00

\*120\*

QC

Memo

0.00

Quality Control

6 RT 12-05-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 82133

**\*82133\***

Page 2

March-23-12 10:47:00 AM

Item ID: D2938-1      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
Revision ID:      Stop **\*NS2\***  
Item Name: Saddle LH Out, 206  
Start Date: 23/03/2012      Start Qty: 6.00      **\*6\***      Cust Item ID:  
Required Date: 06/04/2012      Req'd Qty: 6.00      **\*6\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC8- Inspect parts - second check	0.00							
<b>*130*</b>									
QC	Memo	0.00	B.A	12/05/30		C	φ		
Quality Control									

140	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*140*</b>									
HandFinish	Memo	0.00							
Hand Finishing									

150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*150*</b>									
Powdercoat	Memo	0.00							
Powder Coating									

m 121134

10-40  
START TIME: 3200F OVEN TEMPERATURE:  
FINISH TIME: 11-10

Ce 7/15/12 5-31  
6X φ 12/05/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 82133

**\*82133\***

Page 3

March-23-12 10:47:00 AM

Item ID: D2938-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle LH Out, 206  
 Start Date: 23/03/2012 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 06/04/2012 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
<b>*160*</b>									
QC	Memo	0.00				6	0		BLD 5-81
Quality Control									
170	Identify as per dwg & Stock Location: <u>426</u>	0.00							
<b>*170*</b>									
Packaging	Memo	0.00							P44/01 (6)
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							12/6/48
Quality Control									

MLJ 12/06/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March-23-12 10:47:04 AM

Page 1

Work Order ID: 82133

\*82133\*

Parent Item: D2938-1

\*D2938-1\*

Parent Item Name: Saddle LH Out, 206

Start Date: 23/03/2012

Required Date: 06/04/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069)EC  
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-003		Manufactured	No			100	Each	46.0000	1	6			
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\*D6101-003\*

Saddle Billet, 7075

B83310

\*\*

25 12-05-27

Location

Loc Qty

Loc Code

MAT040

26

73775

2

73780

7

78599

10

MAT041

26

79587

4

80765

22

MAT042

-7

MAT044

1

73769

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>82133</b>
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b>	<b>D2938-1</b>
<b>Inspection Dwg:</b> D2938 Rev. C		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.123	.125	.123	.126		
B	0.100	0.140		.125	.125	.121	.124		
C	0.100	0.140		.125	.125	.125	.124		
D	0.210	0.230		.222	.223	.220	.220		
E	1.245	1.255		1.249	1.249	1.248	1.250		
F	1.245	1.255		1.250	1.250	1.249	1.249		
G	2.495	2.505		2.499	2.500	2.500	2.500		
H	0.510	0.515		.511	.511	.511	.511		
I	1.572	1.582		1.577	1.578	1.578	1.577		
J	2.495	2.505		2.499	2.499	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.119	.117	.120	.119		
O	0.540	0.560		.548	.550	.550	.549		
P	0.490	0.510		.497	.500	.499	.500		
Q	3.715	3.725		3.720	3.720	3.721	3.720		
R	2.720	2.760		2.740	2.741	2.740	2.741		
S	0.240	0.270		.252	.253	.252	.252		
T	0.100	0.180		.139	.143	.141	.140		
U	1.625	1.635		1.635	1.630	1.630	1.630		
V	1.362	1.372		1.368	1.368	1.368	1.368		
W	0.316	0.321		.316	.316	.316	.316		
X	1.250	1.270		1.260	1.260	1.261	1.258		
Y	1.565	1.585		1.575	1.575	1.576	1.574		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	AT
Date:	12-05-28

Audited by:	H.A.
Date:	12/05/30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>82133</b>
<b>Description: 206 Saddle, Outboard, Left side</b>	<b>Part Number:</b>	<b>D2938-1</b>
<b>Inspection Dwg: D2938 Rev. C</b>		<b>Page 1 of 1</b>

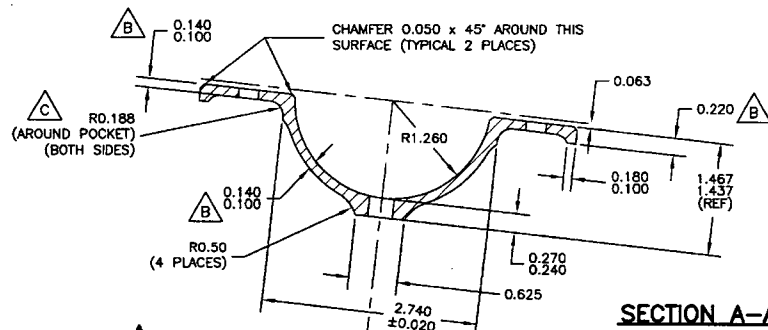
Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	5A	6A	By	Date
A	0.100	0.140		.123		.124	.130		
B	0.100	0.140		.125		.124	.130		
C	0.100	0.140		.128		.123	.126		
D	0.210	0.230		.227		.219	.222		
E	1.245	1.255		1.249		1.250	1.250		
F	1.245	1.255		1.250		1.250	1.250		
G	2.495	2.505		2.497		2.501	2.501		
H	0.510	0.515		.511		.511	.511		
I	1.572	1.582		1.577		1.578	1.578		
J	2.495	2.505		2.497		2.500	2.500		
K	0.257	0.262		.258		.258	.258		
L	0.312	0.317		.314		.314	.314		
M	0.235	0.240		.238		.238	.238		
N	0.100	0.140		.119		.118	.119		
O	0.540	0.560		.548		.550	.550		
P	0.490	0.510		.497		.497	.500		
Q	3.715	3.725		3.720		3.722	3.721		
R	2.720	2.760		2.740		2.741	2.740		
S	0.240	0.270		.252		.253	.251		
T	0.100	0.180		.137		.140	.139		
U	1.625	1.635		1.638		1.630	1.630		
V	1.362	1.372		1.369		1.367	1.368		
W	0.316	0.321		.316		.316	.316		
X	1.250	1.270		1.260		1.261	1.258		
Y	1.565	1.585		1.575		1.576	1.574		
Z	0.178	0.198		.188		.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

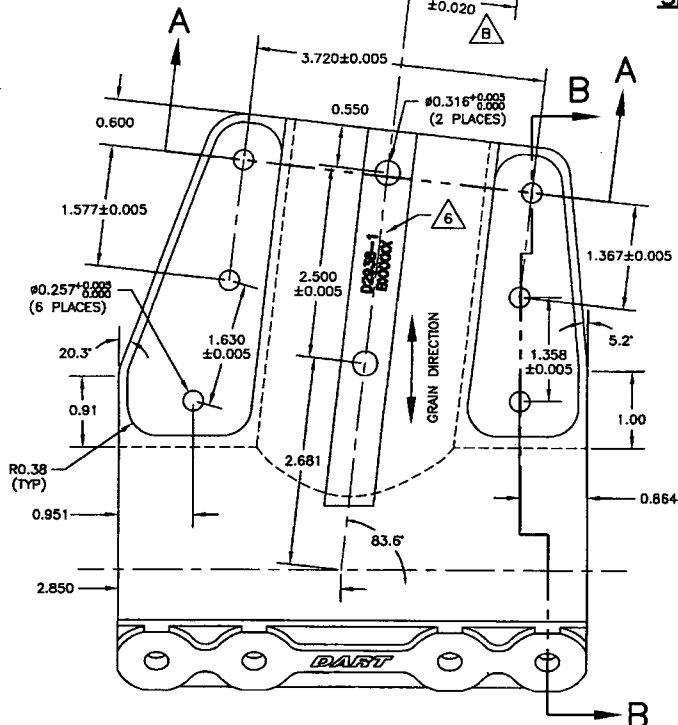
Measured by:	21 12 05 28
Date:	

Audited by:	DA
Date:	12/05/30

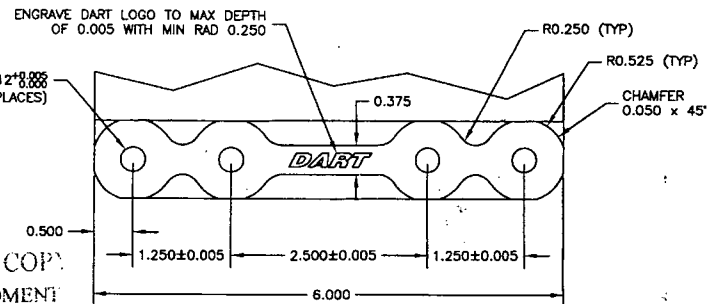
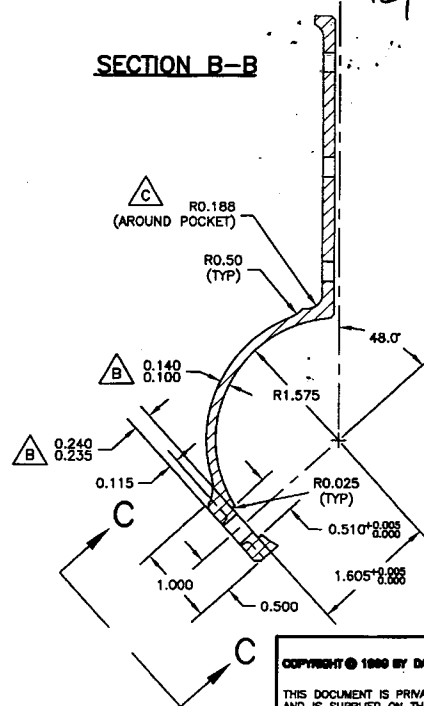
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



SECTION A-A



SECTION B-B



VIEW C-C

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 82133 MLC

12/03/23

D2938-1 LH SADDLE (SHOWN)  
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE OUTSIDE

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**DART** DART AEROSPACE USA, INC.  
BELLEVUE, WA

DRAWING NO. D2938

REV. C

SHEET 1 OF 1

SCALE

2:3

07.02.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries